

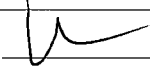
Work Order ID 124662

124662


Page 1

September-19-14 7:38:40 AM

Item ID: D2600-3-BENT-LH Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Extrusion Bent LH
 Start Date: 9/19/14 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 9/26/14 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D2600 | Rev E | | | | | | | | |
| D2750 | G | | | | | | | | |
| 100 | BENDING MACHINE - SKIDTUBES | 0.00 | | | | | | | |
| *100* | | | | | | | | | |
| CNC Bend 1 | Memo | 0.00 | | | | | | | |
| CNC Delta 100 Bender | Pick qty 1 D2600-3-130 extrusion | | | | | | | | |
| | 1-Deburr one end of extrusion | | | | | | | | |
| | 2-Bend using CNC bending machine as per program 2750.C and Folio 14 use bending aid DT9635 | | | | | | | | |
| | 3- cut fwd end of tube as per dwg D2750 | | | | | | | | |
| | 4- cut aft end of tube as per dwg D2750 | | | | | | | | |
| 110 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

 14-9-24
 (6)

DAS
18
9-09

6 8 14-09-24

Work Order ID 124662

September-19-14 7:38:40 AM

124662

Page 2

Item ID: D2600-3-BENT-LH

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Extrusion Bent LH

Start Date: 9/19/14 Start Qty: 6.00

6

Cust Item ID:

Required Date: 9/26/14 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 120 | Identify as per dwg & Stock Location: 46 | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 130 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

14-9-24
6

14-09-25

14-9-25

Picklist Print

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Page 1

Work Order ID: 124662

124662

Parent Item: D2600-3-BENT-LH

D2600-3-BFNT-1 H

Parent Item Name: Extrusion Bent LH

Start Date: 9/19/14

Required Date: 9/26/14

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 14.01.14 NEW ISSUE DD VERF:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D2600-3-130

Manufactured

No

Each

51.0000

6

D2600-3-130

Extrusion Round 3" 350

14-9-24

Location

Loc Qty

Loc Code

LG

51

115858

51

6

| QTY -041 | QTY -042 | QTY -043 | QTY -044 | PART NUMBER | DESCRIPTION |
|-------------|-------------|-------------|-------------|---------------|--|
| X | | | | D2750-041 | 350 SKIDTUBE ASSEMBLY, LH |
| | X | | | D2750-042 | 350 SKIDTUBE ASSEMBLY, RH |
| | | X | | D2750-043 | 350 SKIDTUBE ASSEMBLY, LH |
| | | | X | D2750-044 | 350 SKIDTUBE ASSEMBLY, RH |
| 1 | 1 | 1 | 1 | D2739 | WEB |
| 8 | 8 | 8 | 8 | D2743 | SPACER |
| 1 | 1 | 1 | 1 | D2744 | CAP |
| 8 | 8 | 8 | 8 | D2745 | BUSHING |
| 1 | | | | D2750-1 | SKIDTUBE WELDMENT, LH |
| | 1 | | | D2750-2 | SKIDTUBE WELDMENT, RH |
| | | 1 | | D2750-3 | SKIDTUBE WELDMENT, LH |
| | | | 1 | D2750-4 | SKIDTUBE WELDMENT, RH |
| 1 | | 1 | | D3488-041 | BLADE FITTING, LH |
| | 1 | | 1 | D3488-042 | BLADE FITTING, RH |
| 4 | 4 | 4 | 4 | D3490-1 | SPACER |
| 4 | 4 | | | D3490-3 | SPACER |
| | | 4 | 4 | D3490-5 | SPACER |
| 8 | 8 | 8 | 8 | D3492-041 | PLUG ASSEMBLY |
| 8 | 8 | | | D3492-043 | PLUG ASSEMBLY |
| | | 8 | 8 | D3492-045 | PLUG ASSEMBLY |
| 1 | 1 | 1 | 1 | D3535-25 | WEARSHOE |
| 1 | 1 | 1 | 1 | D3536-25 | GASKET |
| 3 | 3 | 3 | 3 | D3537-1 | WEARPAD |
| 8 | 8 | 8 | 8 | D3631-1 | WASHER |
| 1 | 1 | 1 | 1 | D3791-1 | WEARPLATE |
| 1 | 1 | 1 | 1 | D3793-1 | WEARSHOE |
| 1 | 1 | 1 | 1 | D3793-3 | WEARSHOE |
| 1 | 1 | 1 | 1 | D3794-1 | GASKET |
| 1 | 1 | 1 | 1 | D3794-3 | GASKET |
| 38 | 38 | 38 | 38 | ALS4-1032-225 | INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225) |
| 34 | 34 | 34 | 34 | AN3C5A | BOLT |
| 4 | 4 | 4 | 4 | AN3C6A | BOLT |
| 4 | 4 | 4 | 4 | AN6C44A | BOLT |
| 1 | 1 | 1 | 1 | AN8C35A | BOLT |
| 38 | 38 | 38 | 38 | AN960C10L | WASHER |
| 1 | 1 | 1 | 1 | AN960C816L | WASHER |
| 4 | 4 | 4 | 4 | MS21043-6 | NUT |
| 1 | 1 | 1 | 1 | MS21083C8 | NUT |
| 4 | 4 | 4 | 4 | NAS1515H3L | WASHER |

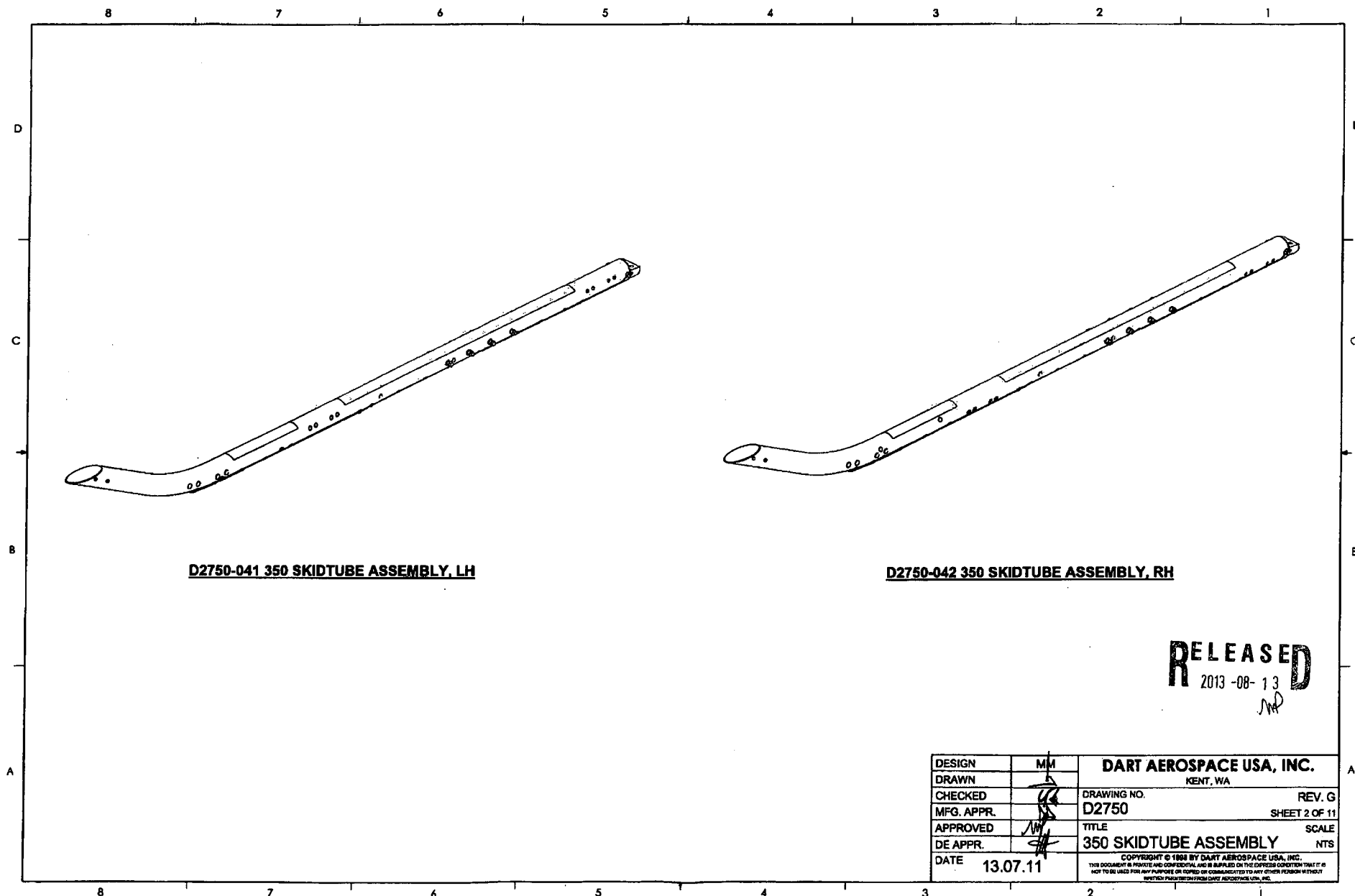
GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

W/O 124662

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| | | | |
|------------|---|---|---------------|
| G | CORRECTED TOLERANCE ON Ø0.500 THRU HOLE: IS +0.010/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR13-276 AND NCR13-2757 | MB | 13.07.11 |
| F | INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043 | PH | 08.07.16 |
| E | CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8 | CB | 07.05.17 |
| D | ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157 | PH | 06.01.05 |
| C | ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740 | CP | 98.11.18 |
| B | CHANGE MS24694-S293 TO AN8-16A | CP | 98.09.01 |
| A | NEW ISSUE | DS | 98.04.16 |
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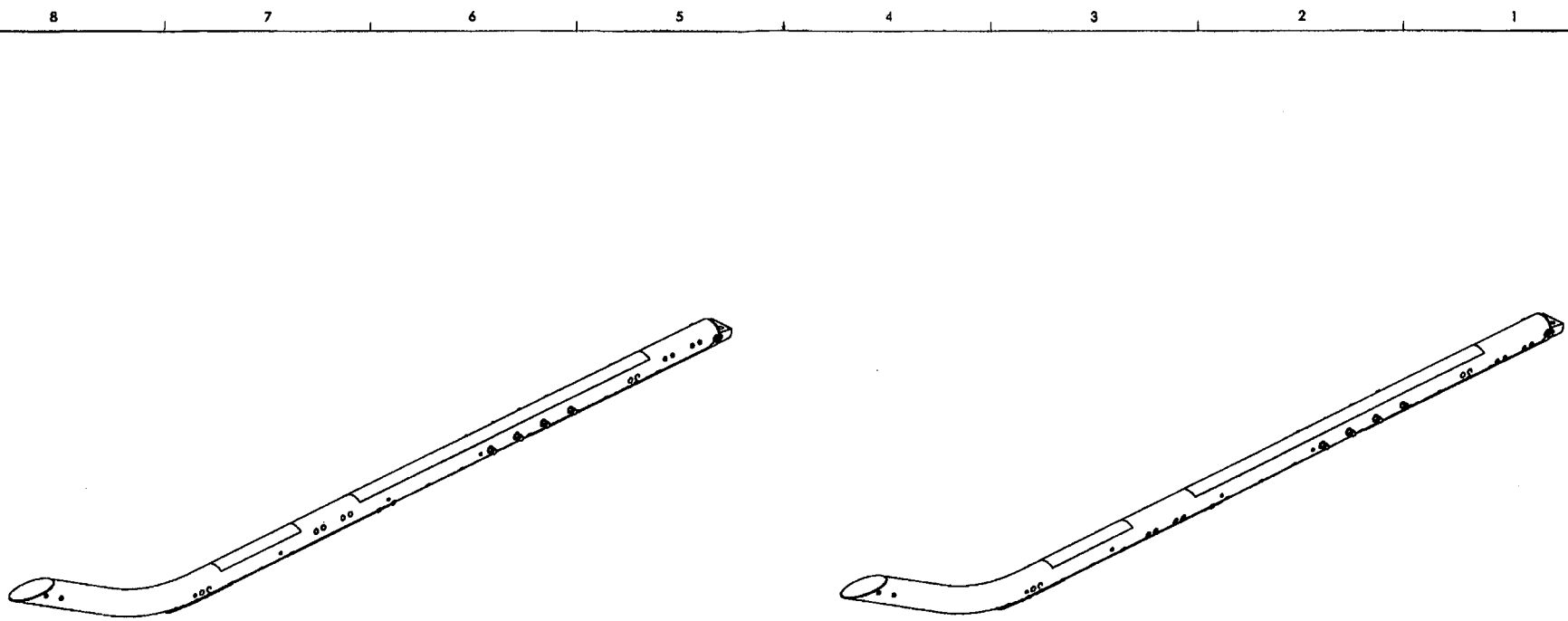


D2750-041 350 SKIDTUBE ASSEMBLY, LH

D2750-042 350 SKIDTUBE ASSEMBLY, RH

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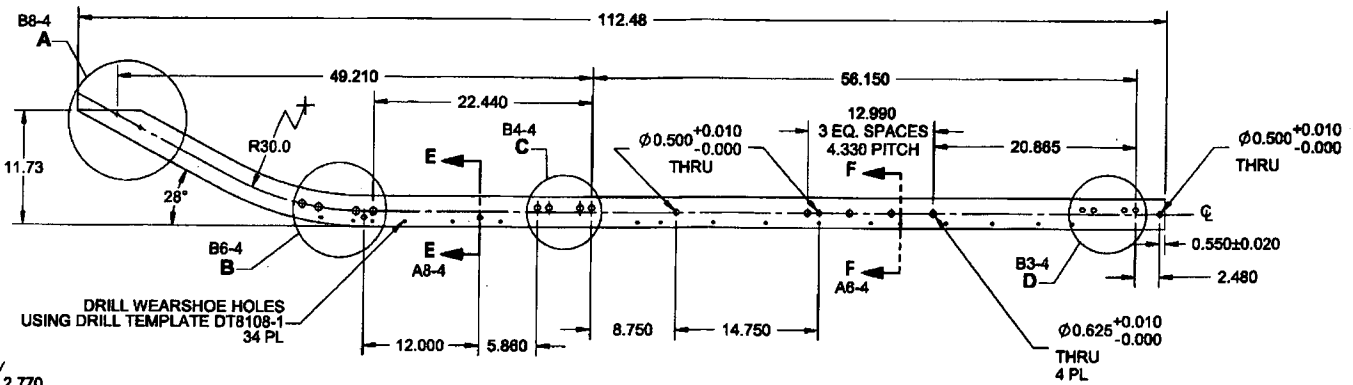
D2750-043 350 SKIDTUBE ASSEMBLY, LH

D2750-044 350 SKIDTUBE ASSEMBLY, RH

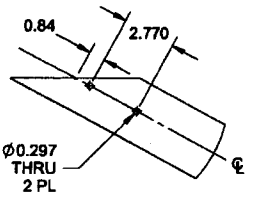
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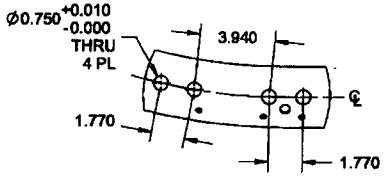
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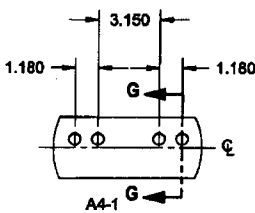
D2750-1 LH SKIDTUBE



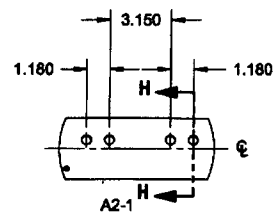
DETAIL A
SCALE 2X



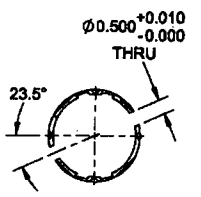
DETAIL B
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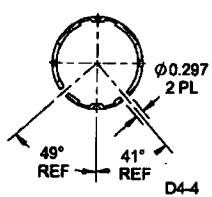
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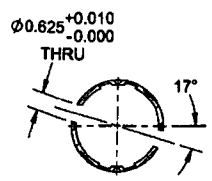
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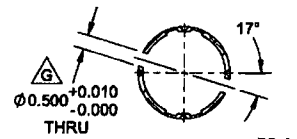
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



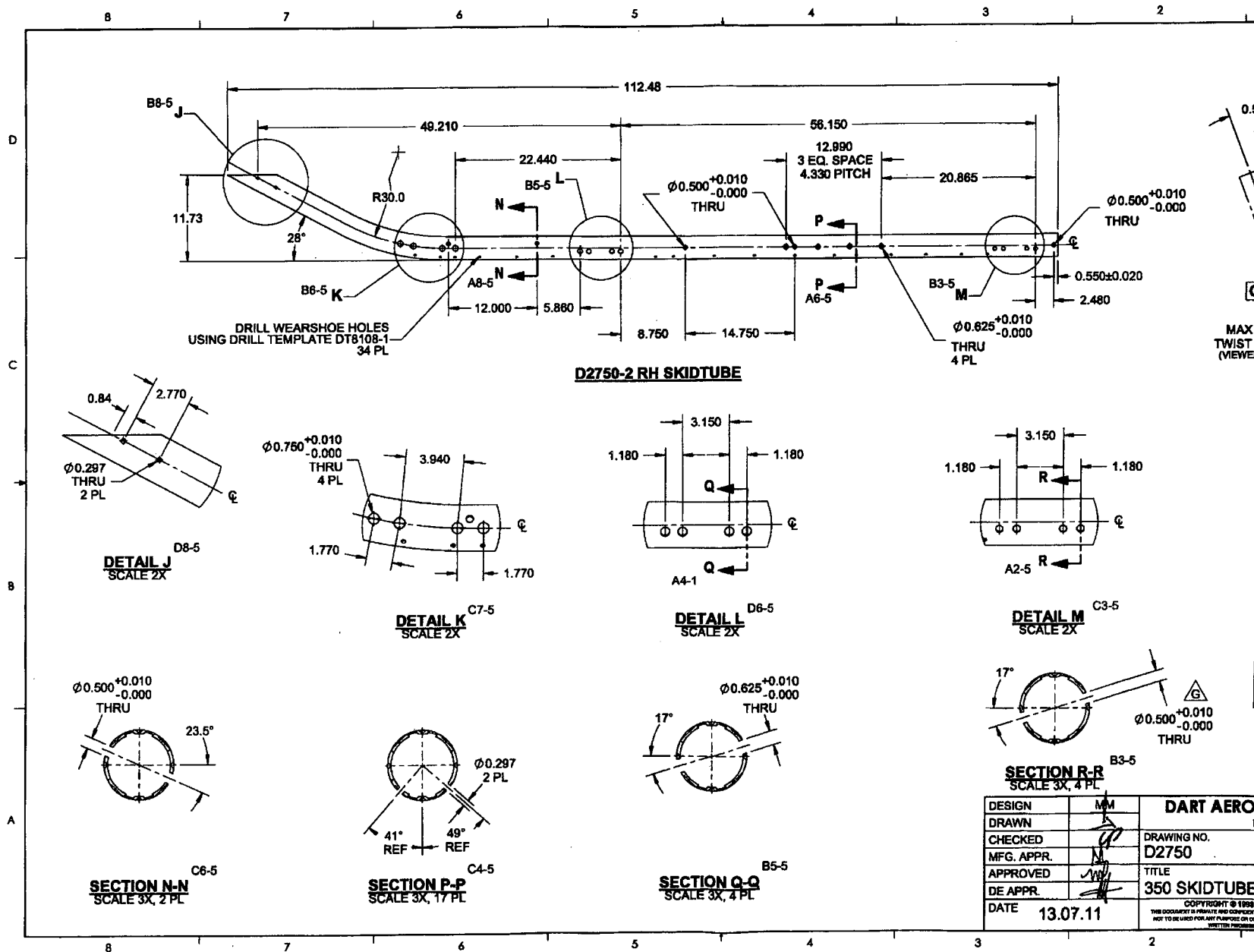
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SCALE 3X, 4 PL

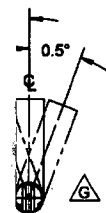
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8 7 6 5 4 3 2 1





ALLOWABLE
N FWD BEND
(LOOKING FWD)

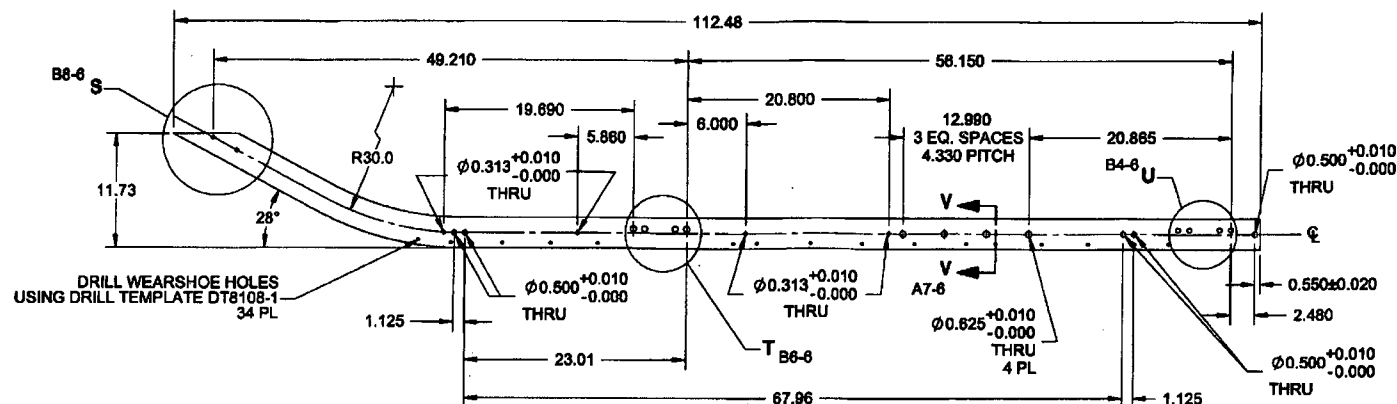
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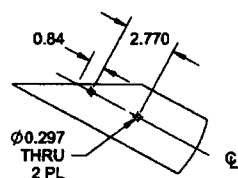
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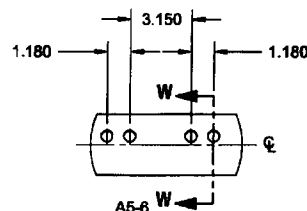
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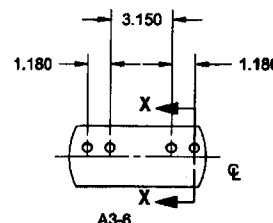
D2750-3 LH SKIDTUBE



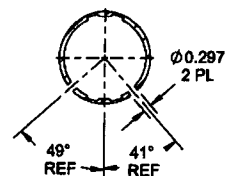
DETAIL S
D8-6
SCALE 2X



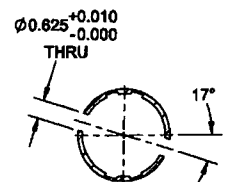
DETAIL T
C5-6
SCALE 2X



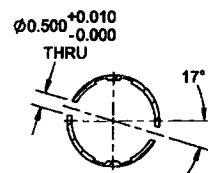
DETAIL U
D3-6
SCALE 2X



SECTION V-V
C4-6
SCALE 3X, 17 PL



SECTION W-W
B8-6
SCALE 3X, 4 PL

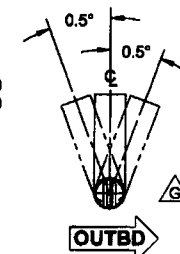
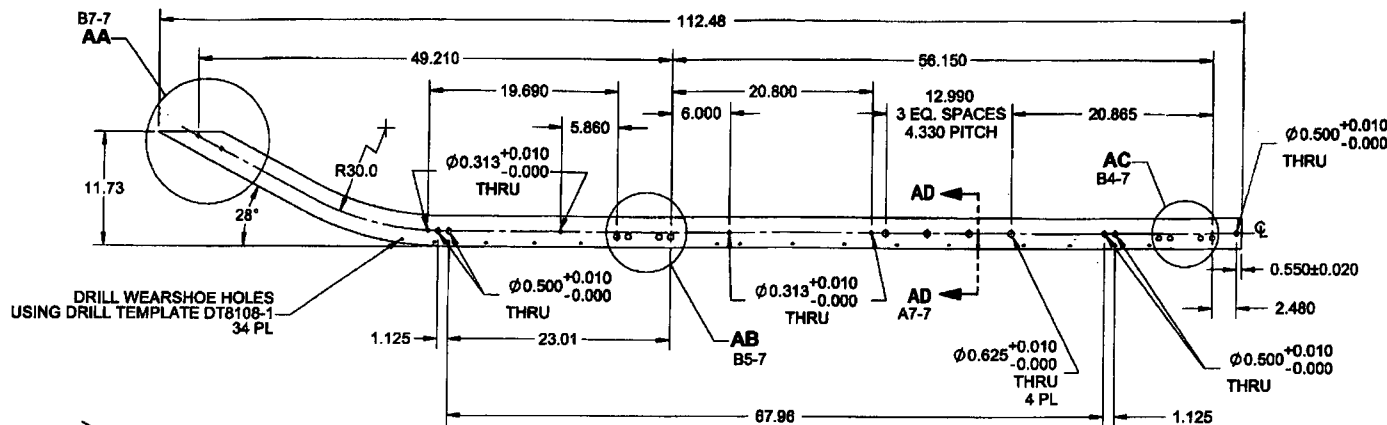


SECTION X-X
B4-6
SCALE 3X, 4 PL

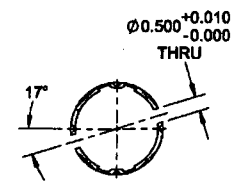
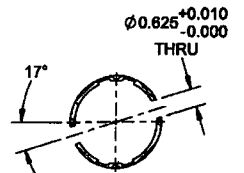
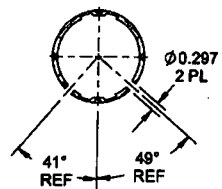
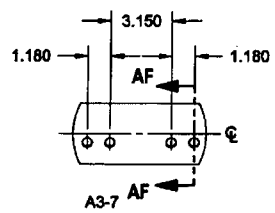
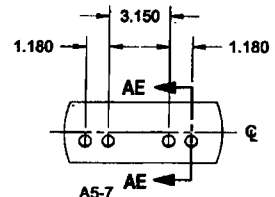
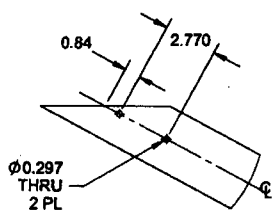
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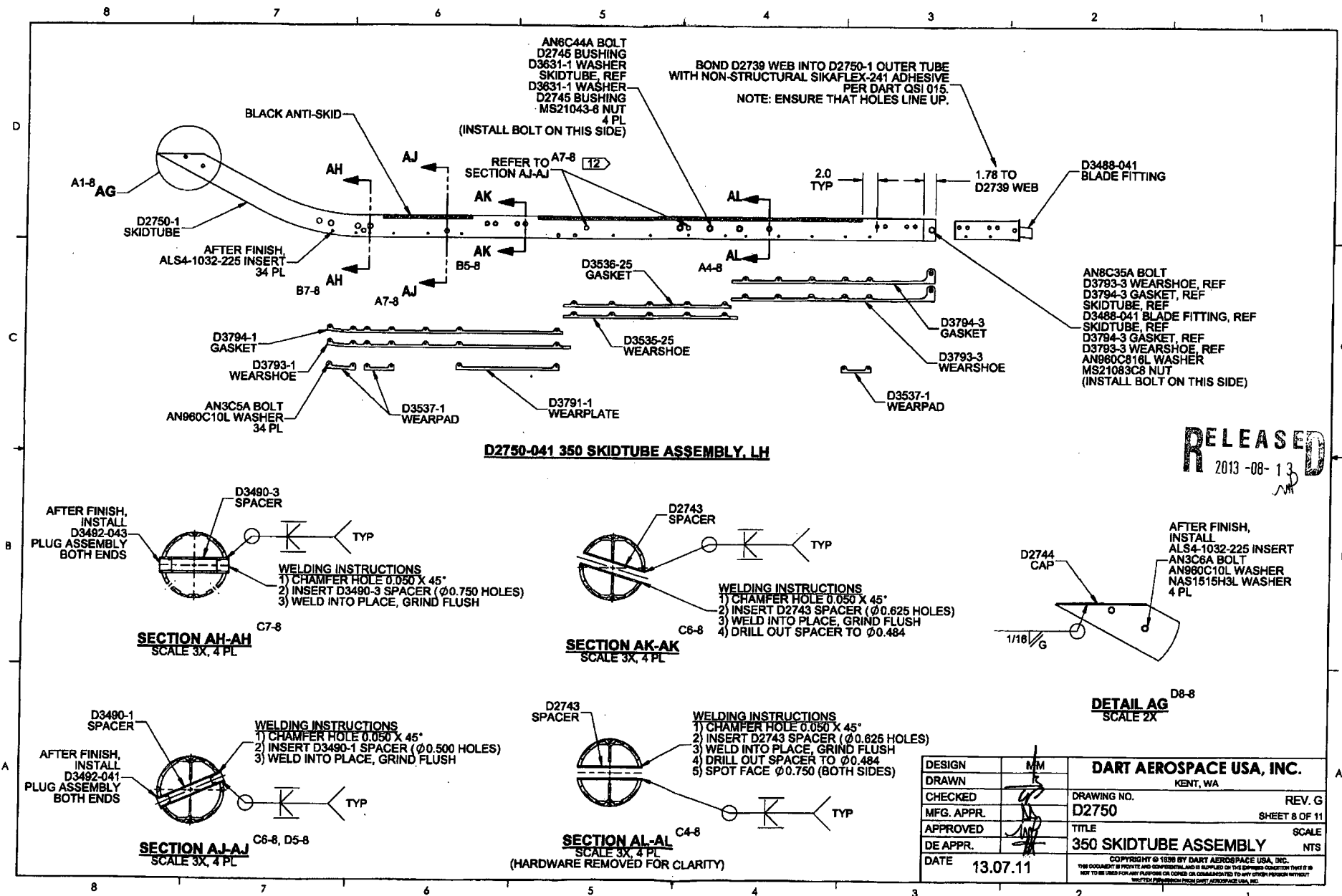


MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)



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8 7 6 5 4 3 2 1

A1-9
AM

D2750-2
SKIDTUBE
AFTER FINISH,
ALS4-1032-225 INSERT
34 PL

BLACK ANTI-SKID

AN

AP

AQ

REFER TO
SECTION AP-AP

A7-9

13

BOND D2739 WEB INTO D2750-2 OUTER TUBE
WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE
PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.

2.0
TYP

1.78 TO
D2739 WEB

D3488-042
BLADE FITTING

D3794-1
GASKET

D3793-1
WEARSHOE

AN3C5A BOLT
AN980C10L WASHER
34 PL

D3537-1
WEARPAD

D3791-1
WEARPLATE

D3538-26
GASKET

D3535-25
WEARSHOE

D3794-3
GASKET

D3793-3
WEARSHOE

D3537-1
WEARPAD

AN8C35A BOLT
D3793-3 WEARSHOE, REF
D3794-3 GASKET, REF
SKIDTUBE, REF
D3488-042 BLADE FITTING, REF
SKIDTUBE, REF
D3794-3 GASKET, REF
D3793-3 WEARSHOE, REF
AN980C816L WASHER
MS21083C8 NUT
(INSTALL NUT ON THIS SIDE)

D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2013-08-13

D3490-3
SPACER
AFTER FINISH,
INSTALL
D3492-043
PLUG ASSEMBLY
BOTH ENDS
WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-3 SPACER (Ø 0.750 HOLES)
3) WELD INTO PLACE, GRIND FLUSH

SECTION AN-AN SCALE 3X, 4 PL

C7-9

D2743
SPACER
WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (Ø 0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO Ø 0.484

SECTION AQ-AQ SCALE 3X, 4 PL

C5-9

D2744
CAP
AFTER FINISH,
INSTALL
ALS4-1032-225 INSERT
AN3C6A BOLT
AN980C10L WASHER
NAS1515H3L WASHER
4 PL

DETAIL AM SCALE 2X

D8-9

AFTER FINISH,
INSTALL
D3492-041
PLUG ASSEMBLY
BOTH ENDS
WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-1 SPACER (Ø 0.500 HOLES)
3) WELD INTO PLACE, GRIND FLUSH

SECTION AP-AP SCALE 3X, 4 PL

C8-9, D5-9

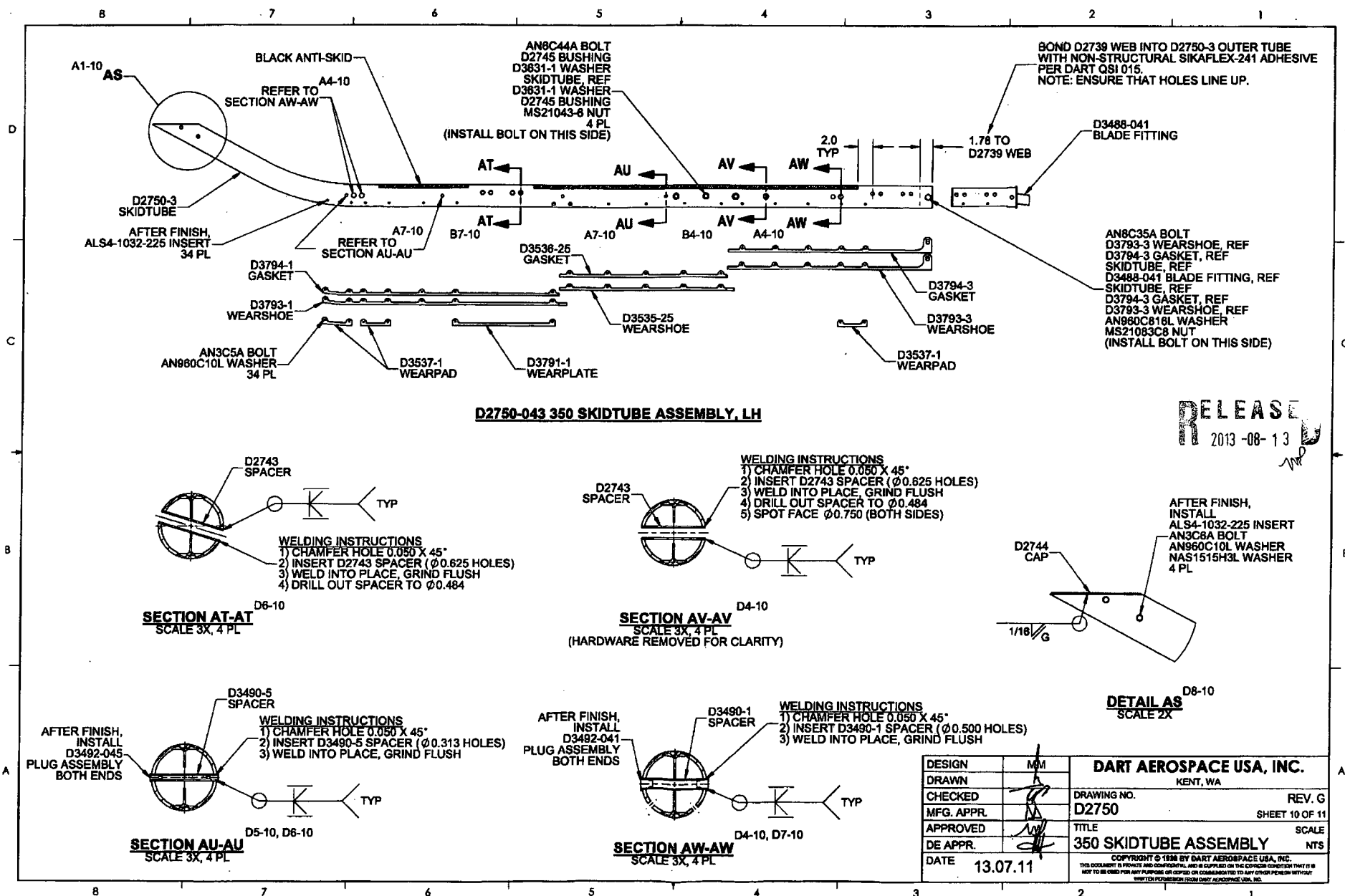
D2743
SPACER
WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (Ø 0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO Ø 0.484
5) SPOT FACE Ø 0.750 (BOTH SIDES)

SECTION AR-AR SCALE 3X, 4 PL

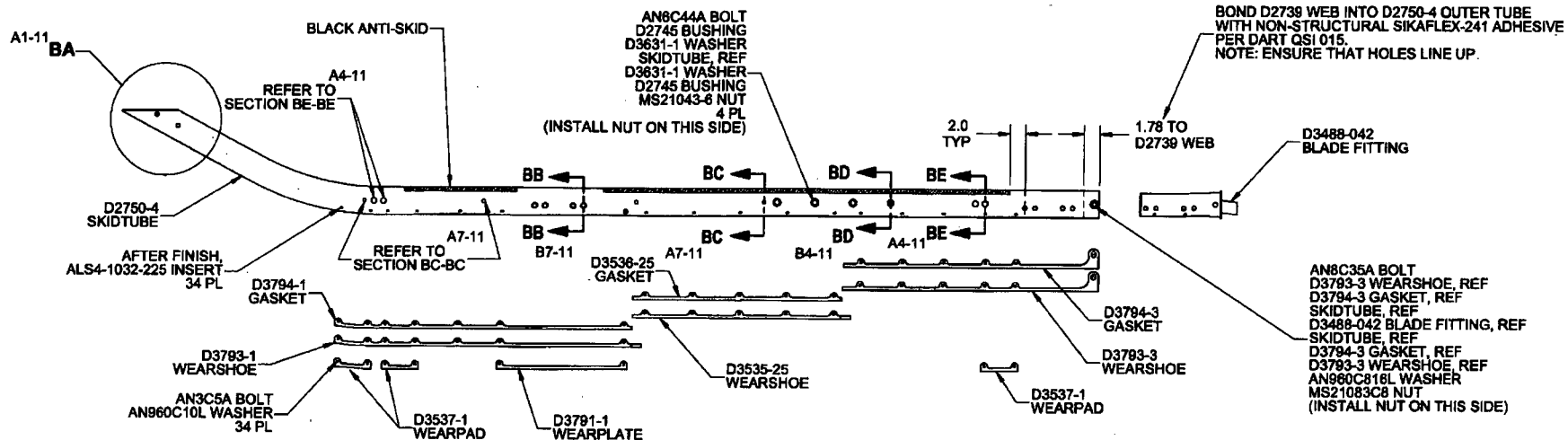
(HARDWARE REMOVED FOR CLARITY)

| | | | |
|------------|----------|---|---------------|
| DESIGN | MM | DART AEROSPACE USA, INC. | |
| DRAWN | | KENT, WA | |
| CHECKED | | DRAWING NO. | REV. G |
| MFG. APPR. | | D2750 | SHEET 9 OF 11 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | 350 SKIDTUBE ASSEMBLY | NTS |
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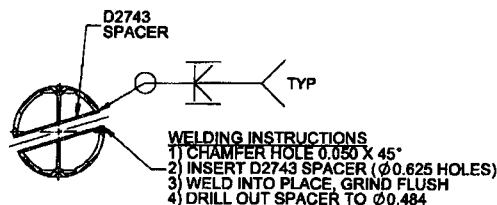
8 7 6 5 4 3 2 1



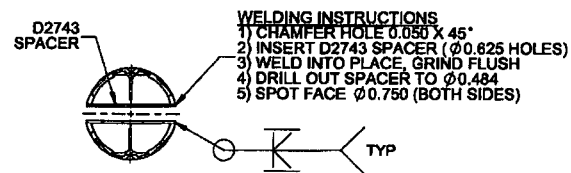
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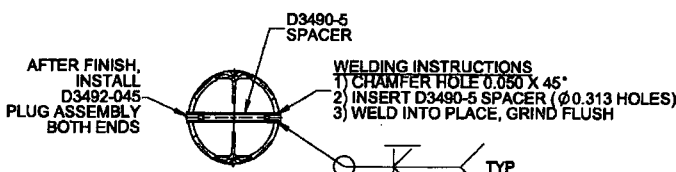
D2750-044 350 SKIDTUBE ASSEMBLY, RH



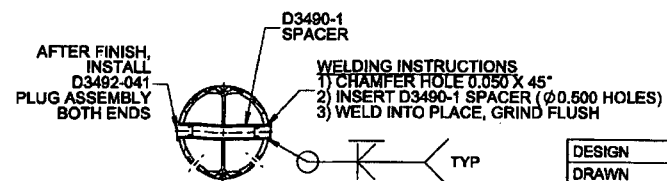
SECTION BB-BB
SCALE 3X, 4 PL



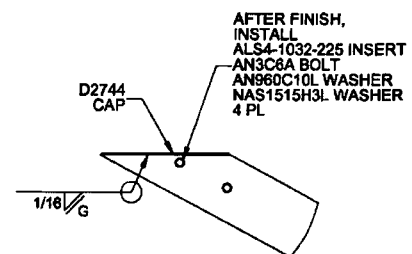
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

| | | | |
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| MFG. APPR. | | D2750 | SHEET 11 OF 11 |
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| DE APPR. | | 350 SKIDTUBE ASSEMBLY | NTS |
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2013-08-13

